

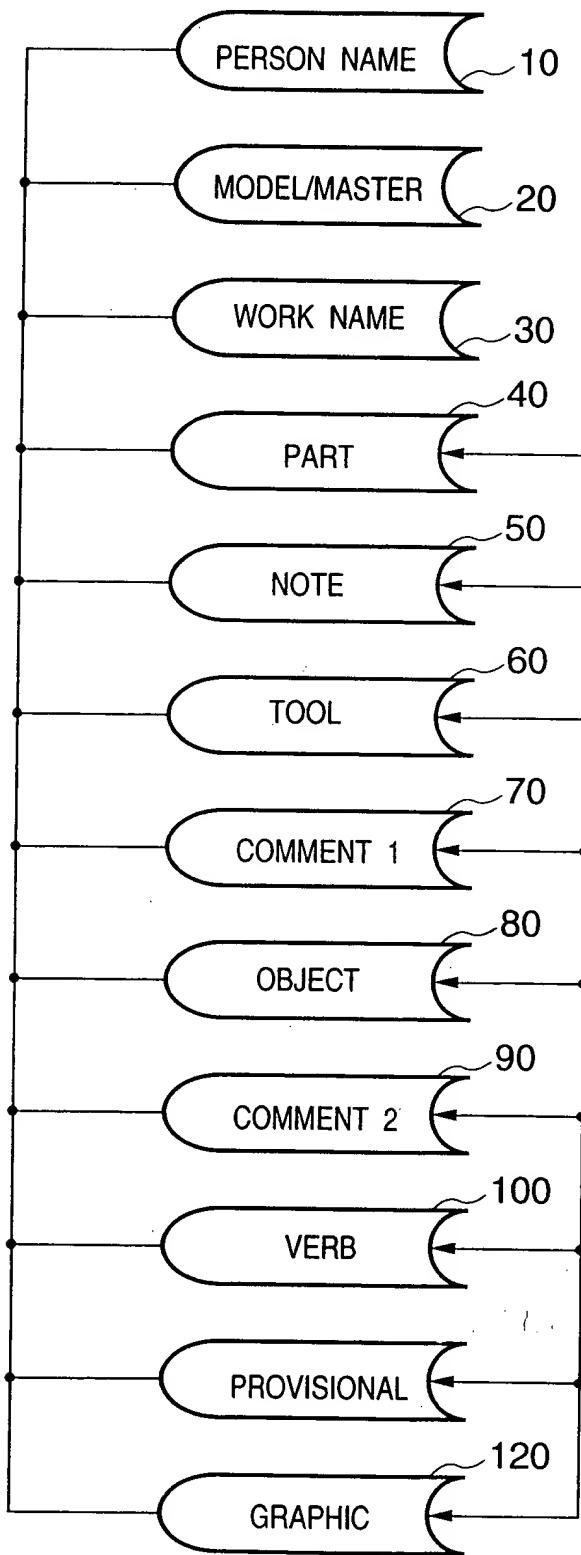
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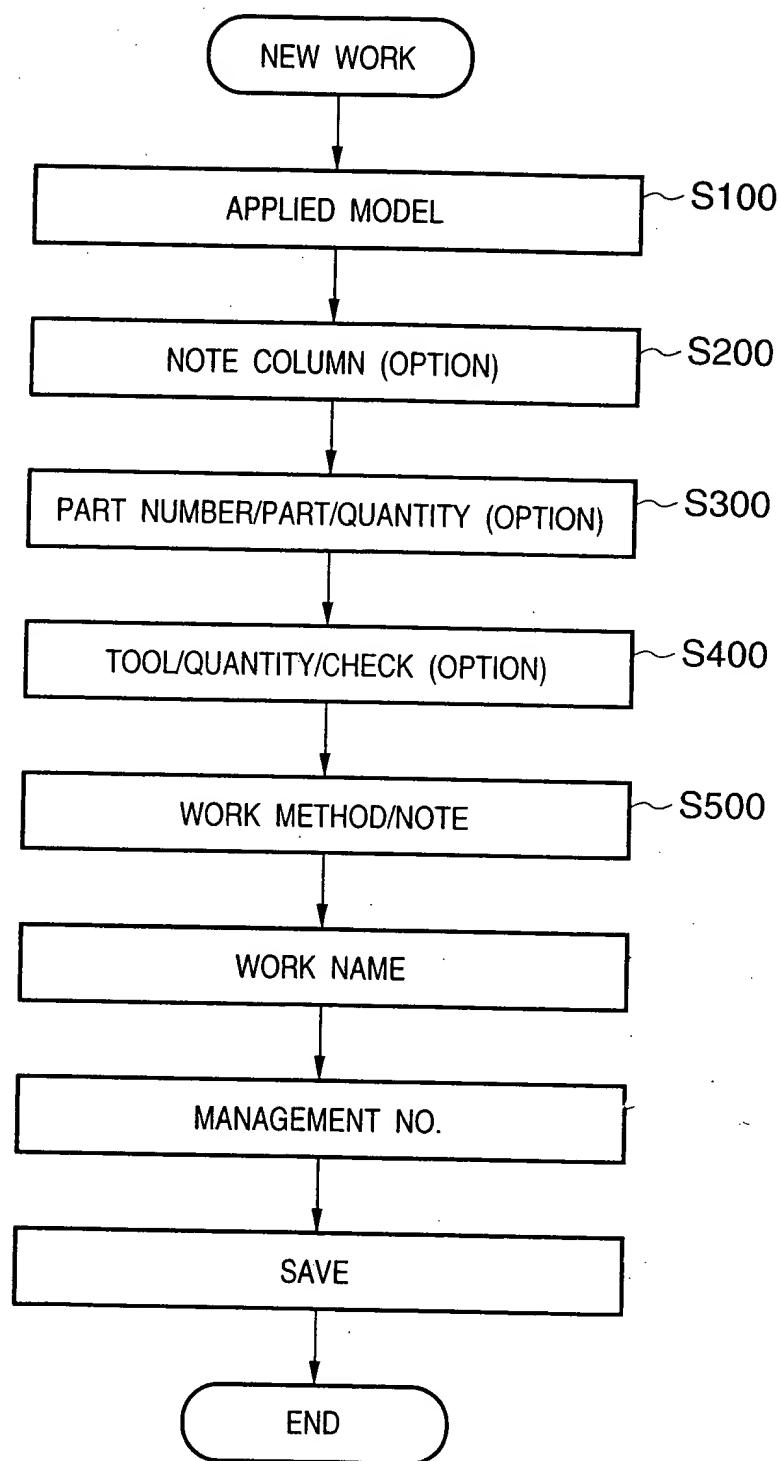
FIG. 4

STRUCTURE OF MASTER FILE



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FIG. 5



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FIG. 23

WORK STANDARD SYSTEM			
<input checked="" type="radio"/> LATEST REVISION NUMBER	<input type="radio"/> ALL		
MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO - 04 - 01(4) - E	01	SET ASFU	1997/09/13
SO - 01 - 01(3) - E	01	SET BASE TRAY	1997/09/01
SO - 01 - 03 - E	01	SET BASE TRAY	1997/09/01
SO - 01 - 04 - E	01	SET BASE TRAY	1997/09/01
SO - 06 - 01 - E	01	WIRING	1997/09/01
SO - 06 - 02 - E	01	WIRING	1997/09/01
SO - 06 - 03 - E	01	WIRING	1997/09/01
SO - 07 - 01(2) - E	01	GREASING	1997/09/01
SO - 08 - 01 - E	01	SET RAIL	1997/09/01

◀ ▶

OK CANCEL

2301

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2500

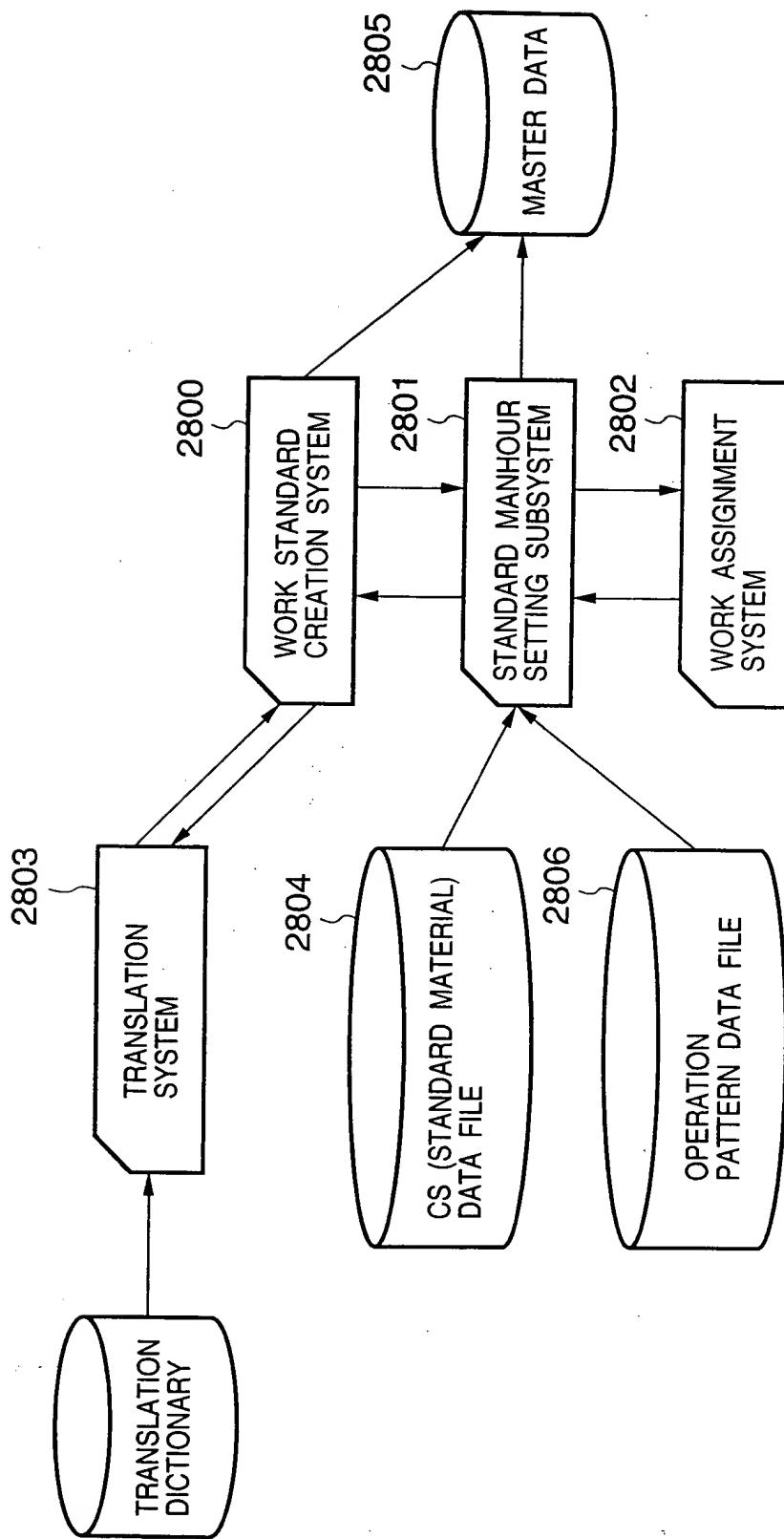
FIG. 25

WORK STANDARD 01 CREATION									
<input type="checkbox"/> APPLIED									
<table border="1"> <tr> <td>PART NUMBER</td> <td>PART NAME</td> </tr> <tr> <td>303</td> <td>TOOL / TREATMENT DEVICE</td> </tr> </table>		PART NUMBER	PART NAME	303	TOOL / TREATMENT DEVICE				
PART NUMBER	PART NAME								
303	TOOL / TREATMENT DEVICE								
<table border="1"> <tr> <td>FILE NAME :</td> <td>UPDATE</td> <td>CLEAR</td> <td>CLOSE</td> </tr> <tr> <td colspan="4">2501</td> </tr> </table>		FILE NAME :	UPDATE	CLEAR	CLOSE	2501			
FILE NAME :	UPDATE	CLEAR	CLOSE						
2501									
No.	WORK PROCEDURE								
REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME				
01	CREATED	1997/09/25							
					MANAGEMENT NO.				

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FIG. 28



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FIG. 30

TRANSLATION OF WORK STANDARD					
3001	3002	3003	3004	3005	3006
REPRESENTATIVE MODEL NAME : A252 PREPUCES NAME : PLATEN UNIT ○ TOTAL ASSEMBLY ◎ ASSEMBLY		<input checked="" type="checkbox"/> DISPLAY DATA <input checked="" type="radio"/> ALL <input type="radio"/> UNTRANSLATED <input type="radio"/> UNCHECKED		DISPLAY LANGUAGE <input type="radio"/> JAPANESE <input checked="" type="radio"/> ENGLISH	
MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION		CHECK
PT - 010 - 010	01	SET CLEANER UP	X		X
PT - 010 - 020	01	SET CLEANER UP	X		X
PT - 010 - 030	01	SET CLEANER UP	X		X
PT - 070 - 030	01	ASSEMBLE CHANGEOVER ARM	X		
PT - 080 - 010	01	SET TRANSMISSION ROLLER	X		X
PT - 090 - 010	01	SET TRANSMISSION ROLLER	X		X
PT - 100 - 010	01	SET SHEET HOLDER	X		X
<input type="checkbox"/> SELECT ALL <input type="checkbox"/> CANCEL SELECT		<input type="checkbox"/> VIEW <input type="checkbox"/> TRANSLATE	<input type="checkbox"/> TRANSLATE ALL <input type="checkbox"/> CLOSE		

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FIG. 31

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FIG. 47

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FIG. 55

SELECTION OF MODEL									
FILE(E)		EDIT(E)		VIEW(V)					
<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PRODUCT SYMBOL : BJC - 970909		NAME : 097 - 09 - 09 LOAD		SET MODEL SYMBOL : BJC - 4300		LATEST REVISION NUMBER		UPDATE DISPLAY	
COMPONENT SYMBOL : ON		NAME :		NAME : x x x x x					
S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY	◀	▶
N 3	CH-01-01	1	ELECTRIC CHECKING	0	0	0	0		
N 4	CH-01-02(1)	1	ELECTRIC CHECKING	0	0	0	0		
N 5	CH-01-02(2)	1	ELECTRIC CHECKING	0	0	0	0		
N 6	CH-01-03	1	ELECTRIC CHECKING	0	0	0	0		
N 7	CH-01-04	1	ELECTRIC CHECKING	0	0	0	0		
N 23	CH-07-02(1)	1	SET FRONT COVER	0	0	0	0		
N 24	CH-07-02(2)	1	SET FRONT COVER	0	0	0	0		
N 25	CH-07-01(3)	1	SET FRONT COVER	0	0	0	0		
N 26	CH-07-01(4)	1	SET FRONT COVER	0	0	0	0		
No.	FORMAL MANAGEMENT NO.	UNIT WORK NAME	MANHOUR	USE	FREQUENCY	1	2	3	4
3	CH-01-01	ELECTRICAL CHECK	0	0	0	1			
CHANGE O INSERT O ADD <input type="checkbox"/> OK									
5501 5507 5506 5502 5503 5504 5505									

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FIG. 56

XXXXX	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
FORMAL MANAGEMENT NO. PU-03-01 UNIT WORK NAME : MOTOR ATTACHMENT TOTAL MANHOUR : <input type="text"/> 0 NEXT UNIT WORK : <input type="checkbox"/>							
NO.	ELEMENT WORK NAME		REVISION	MANHOUR	US	CS	SET CONDITION
1	SET DOUBLE GEAR TO OPPOSITE SIDE OF AXIS IN ORDER OF SMALL GEAR DIAMETER		1	0	0	0	
*							
<p>COMMENT 1 : TO OPPOSITE SIDE OF AXIS</p> <p>OBJECT : DOUBLE GEAR</p> <p>COMMENT 2 : IN ORDER OF SMALL GEAR DIAMETER</p> <p>VERB : SET</p>							

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FIG. 57

EDITING OF ANALYSIS MATERIAL						
FILE(E) EDIT(E) VIEW(V)						
PRODUCT GENRE : <input type="checkbox"/> ALL <input checked="" type="checkbox"/>						
<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR USE/FREQ. COUNT SET DATE
▲	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50(G1/N)>6/-3	15 0 1 1 0 97/09/09 9:52
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50(E/02/N)-6	11 0 1 1 0 97/09/09 9:53
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50(G1/N)>6/-3	15 0 1 1 0 97/09/09 9:55
	ELEMENT WORK 01			VERB	-50(G1/N)>6/-3	15 0 1 1 0 97/09/09 16:34
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50(G1/N)>6/-3	15 0 1 1 0 97/09/09 19:09
	CARRIAGE LOCK			APPLY	Time100/Rate100	100 1 1 1 1 97/09/09 19:16
	ASSEMBLE PRINTER CHASSIS	MOTOR		INSERT & SET	M2111/10	50 1 1 1 1 97/09/09 17:00
	PRINTER CHASSIS			TURN INSIDE OUT	T1221/M2311/0/0	12 0 1 1 0 97/09/09 17:34
1				1	T2221/M1211/0/1	24 0 1 1 0 97/09/09 17:20
2				2	T1221/M2311/0/0	12 0 1 1 0 97/09/09 17:24
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET			15 0 1 1 0 97/09/09 11:24
	dgdafafas	fdasfasfasfad	*		16 0 1 1 0 97/09/09 12:10	
	dsdsffsdssdf	fdsafsdffds	T21121/M1111/0/1		13 0 1 1 0 97/09/09 12:10	
	dgdafafas	fdasfasfasfad	*		16 0 1 1 0 97/09/09 13:39	
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15 0 1 1 0 97/09/09 14:00	
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15 0 1 1 0 97/09/09 14:00	
	PRINTER UNIT		SET	Time100/Rate100	100 1 1 0 97/09/09 14:04	

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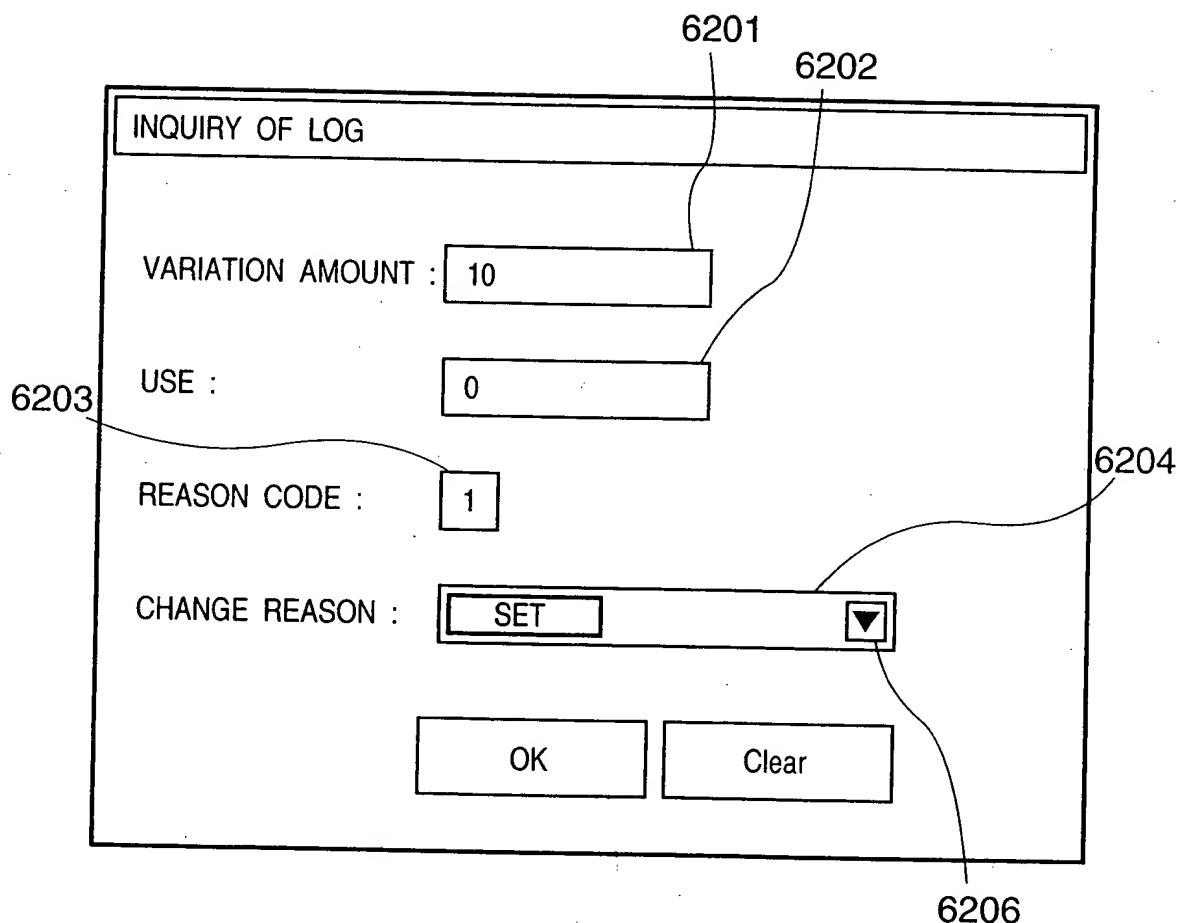
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FIG. 58

OPERATION ANALYSIS													
<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>									
1 SET MAIN BODY TO PREDETERMINED POSITION		TOTAL SIMO VALUE:		<input type="text"/> 0		TOTAL MANHOUR VALUE:		<input type="text"/> 15		<input type="text"/> SIMO		<input type="text"/> NEXT ELEMENT WORK	
NO.	CONTENTS OF OPERATION	WF/OS	SET CONDITION	MANHOUR	USE	REMARKS							
▲ 1	XXXXXX	PU	-60/Gr1/N>6/-3	15	0								
*													

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FIG. 72

		▼	▲									
	FILE(F) EDIT(E)	▼	▲									
PLAN 1		COMPOSITION EFFICIENCY 92 %										
		▼	▲									
	FILE(F) EDIT(E)	▼	▲									
PLAN 1		St 1										
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td>0001</td><td>STICK HANDY CUT TAPE</td><td style="text-align: right;">134</td></tr> <tr><td>0002</td><td>SET LABELS ON MAIN BODY</td><td style="text-align: right;">550</td></tr> <tr><td>0003</td><td>WEIMAN REMOVAL</td><td style="text-align: right;">270</td></tr> </table>				0001	STICK HANDY CUT TAPE	134	0002	SET LABELS ON MAIN BODY	550	0003	WEIMAN REMOVAL	270
0001	STICK HANDY CUT TAPE	134										
0002	SET LABELS ON MAIN BODY	550										
0003	WEIMAN REMOVAL	270										
St 2												
<p style="text-align: center;">DRAG AND DROP</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr><td>0004</td><td>ASSEMBLE OUTER CASE</td><td style="text-align: right;">365</td></tr> <tr><td>0005</td><td>FIT TOP PAD</td><td style="text-align: right;">268</td></tr> <tr><td>0006</td><td>STICK LARGE-SIDE ORDER LABEL</td><td style="text-align: right;">117</td></tr> </table>				0004	ASSEMBLE OUTER CASE	365	0005	FIT TOP PAD	268	0006	STICK LARGE-SIDE ORDER LABEL	117
0004	ASSEMBLE OUTER CASE	365										
0005	FIT TOP PAD	268										
0006	STICK LARGE-SIDE ORDER LABEL	117										
		OK	CANCEL									

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FIG. 73

	FILE(F) EDIT(E)										
PLAN 2 COMPOSITION EFFICIENCY 92 %											
PLAN 2 St 1											
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">0001</td> <td style="width: 60%;">STICK HANDY CUT TAPE</td> <td style="width: 30%;">134</td> </tr> <tr> <td>0002</td> <td>SET LABELS ON MAIN BODY</td> <td>550</td> </tr> <tr> <td>0008</td> <td>XXXX</td> <td>270</td> </tr> </table>			0001	STICK HANDY CUT TAPE	134	0002	SET LABELS ON MAIN BODY	550	0008	XXXX	270
0001	STICK HANDY CUT TAPE	134									
0002	SET LABELS ON MAIN BODY	550									
0008	XXXX	270									
DRAG AND DROP											
St 2											
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">0003</td> <td style="width: 60%;">WEIMAN REMOVAL</td> <td style="width: 30%;">365</td> </tr> <tr> <td>0004</td> <td>ASSEMBLE OUTER CASE</td> <td>268</td> </tr> <tr> <td>0005</td> <td>FIT TOP PAD</td> <td>117</td> </tr> </table>			0003	WEIMAN REMOVAL	365	0004	ASSEMBLE OUTER CASE	268	0005	FIT TOP PAD	117
0003	WEIMAN REMOVAL	365									
0004	ASSEMBLE OUTER CASE	268									
0005	FIT TOP PAD	117									
<input type="button" value="OK"/> <input type="button" value="CANCEL"/>											

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FIG. 76

7601	OPEN FILE	7602	TARGET MODEL	7604	NAME	REVISION NUMBER	SAVE DATE															
				<table border="1"> <tr><td>TEST DATA (ORIGINAL)</td><td>1</td><td>97/09/19 12:00:34</td></tr> <tr><td>TEST</td><td>0</td><td>97/09/19 13:27:17</td></tr> <tr><td>BJC-4300</td><td>0</td><td>97/09/19 14:10:14</td></tr> <tr><td>BJC-4300</td><td>0</td><td>97/09/19 14:10:32</td></tr> <tr><td></td><td>1</td><td>97/09/19 15:41:14</td></tr> </table>		TEST DATA (ORIGINAL)	1	97/09/19 12:00:34	TEST	0	97/09/19 13:27:17	BJC-4300	0	97/09/19 14:10:14	BJC-4300	0	97/09/19 14:10:32		1	97/09/19 15:41:14		
TEST DATA (ORIGINAL)	1	97/09/19 12:00:34																				
TEST	0	97/09/19 13:27:17																				
BJC-4300	0	97/09/19 14:10:14																				
BJC-4300	0	97/09/19 14:10:32																				
	1	97/09/19 15:41:14																				
				<table border="1"> <tr><td>BJC-4300A LINE FORMATION</td><td>97/09/20 14:16:38</td></tr> <tr><td>BJC-4300A LINE FORMATION</td><td>03</td></tr> <tr><td>BJC-4300A LINE FORMATION</td><td>00</td></tr> <tr><td>f12-0010A LINE FORMATION</td><td>05</td></tr> <tr><td>f12-0010.csv</td><td></td></tr> </table>		BJC-4300A LINE FORMATION	97/09/20 14:16:38	BJC-4300A LINE FORMATION	03	BJC-4300A LINE FORMATION	00	f12-0010A LINE FORMATION	05	f12-0010.csv								
BJC-4300A LINE FORMATION	97/09/20 14:16:38																					
BJC-4300A LINE FORMATION	03																					
BJC-4300A LINE FORMATION	00																					
f12-0010A LINE FORMATION	05																					
f12-0010.csv																						
						<table border="1"> <tr><td>SELECT WINDOW</td></tr> <tr><td><input type="radio"/> COMPOSITION DATA INPUT WINDOW</td></tr> <tr><td><input type="radio"/> COMPOSITOR DATA CORRECTION WINDOW</td></tr> </table>		SELECT WINDOW	<input type="radio"/> COMPOSITION DATA INPUT WINDOW	<input type="radio"/> COMPOSITOR DATA CORRECTION WINDOW												
SELECT WINDOW																						
<input type="radio"/> COMPOSITION DATA INPUT WINDOW																						
<input type="radio"/> COMPOSITOR DATA CORRECTION WINDOW																						
						<input type="button" value="OK"/> <input type="button" value="CANCEL"/>																

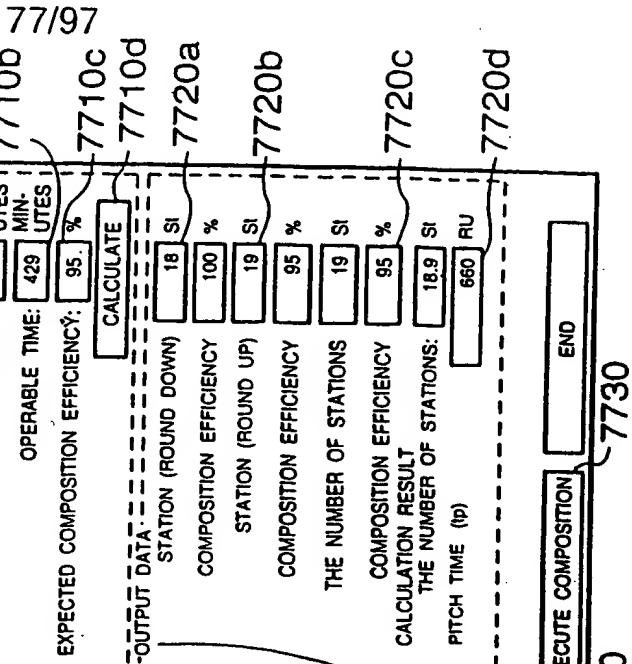
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FIG. 77

7706 7701 7702 7705 7703

INPUT OF COMPOSITION DATA									
FILE(E)	EDIT(E)	TOOL(I)	OPTION(O)						
COMPOSITION DATA		FILE NAME (COMPOSITION NAME)		REVISION NUMBER	6	© WORK	O TOOL	O PART	ONOTE
TARGET MODEL						COMPOSITION MODE	PRIORITY ORDER SCHEME		
PER1000									
1	FIRST NO.	UNIT NAME	WORK STANDARD NO.	WF	MANUAL CHINE	PROVISIONAL MANHOUR	MANHOUR	MANHOUR	MANHOUR
1	1	900000000000000001E	UNIT NAME1	579	579	0	0	0	0
1	2	900000000000000001E	UNIT NAME2	54	54	0	0	0	0
1	3	900000000000000001E	UNIT NAME3	10	10	0	0	0	0
1	4	900000000000000001E	UNIT NAME4	50	50	0	0	0	0
1	5	900000000000000001E	UNIT NAME1	63	63	0	0	0	0
1	27	900000000000000027E	UNIT NAME23	55	55	0	0	0	0
1	28	900000000000000028E	UNIT NAME24	88	88	0	0	0	0
1	29	900000000000000029E	UNIT NAME25	147	147	0	0	0	0
1	30	900000000000000030E	UNIT NAME26	52	52	0	0	0	0
1	31	900000000000000031E	UNIT NAME27	55	55	0	0	0	0
1	32	900000000000000032E	UNIT NAME28	203	203	0	0	0	0
1	33	900000000000000033E	UNIT NAME29	66	66	0	0	0	0
1	34	900000000000000034E	UNIT NAME30	36	36	0	0	0	0
THE NUMBER OF WORKS IN COMPOSITION : <input type="text" value="141"/>									
TOTAL : <input type="text" value="11903"/> (RU)									
TOTAL MANHOUR IN COMPOSITION : <input type="text" value="11903"/> (RU)									
TOTAL MANHOUR OUTSIDE COMPOSITION: <input type="text" value="0"/> (RU)									
TOTAL MANHOUR OUTSIDE WORKSHOP: <input type="text" value="0"/> (RU)									

INPUT DATA									
THE EXPECTED NUMBER OF PRODUCTS:	<input type="text" value="650"/>	UNITS							
THE NUMBER OF DEFECTIVE PRODUCT:	<input type="text" value="0"/>	UNITS							
THE NUMBER OF INITIAL PRODUCTS:	<input type="text" value="556"/>	UNITS							
INVESTED INTO TOP OF ASSEMBLY LINE:	<input type="text" value="556"/>	UNITS							
WORKING TIME:	<input type="text" value="450"/>	MINUTES							
BREAK:	<input type="text" value="15"/>	MINUTES							
MORNING MEETING TIME:	<input type="text" value="1"/>	MINUTES							
EXERCISE TIME:	<input type="text" value="5"/>	MINUTES							
LATE STOP TIME:	<input type="text" value="0"/>	MINUTES							
OTHERS:	<input type="text" value="0"/>	MINUTES							
OPERABLE TIME:	<input type="text" value="429"/>	MINUTES							
EXPECTED COMPOSITION EFFICIENCY:	<input type="text" value="95"/>	%							
CALCULATE <input type="button" value="CALCULATE"/>									
OUTPUT DATA									
STATION (ROUND DOWN)	<input type="text" value="18"/>	SI							
COMPOSITION EFFICIENCY	<input type="text" value="100"/>	%							
STATION (ROUND UP)	<input type="text" value="19"/>	SI							
COMPOSITION EFFICIENCY	<input type="text" value="95"/>	%							
THE NUMBER OF STATIONS	<input type="text" value="19"/>	SI							
COMPOSITION EFFICIENCY	<input type="text" value="95"/>	%							
CALCULATION RESULT	<input checked="" type="checkbox"/>								
THE NUMBER OF STATIONS:	<input type="text" value="18.9"/>	SI							
PITCH TIME (Ip)	<input type="text" value="660"/>	RU							
EXECUTE COMPOSITION	<input type="button" value="EXECUTE COMPOSITION"/>								
END	<input type="button" value="END"/>								



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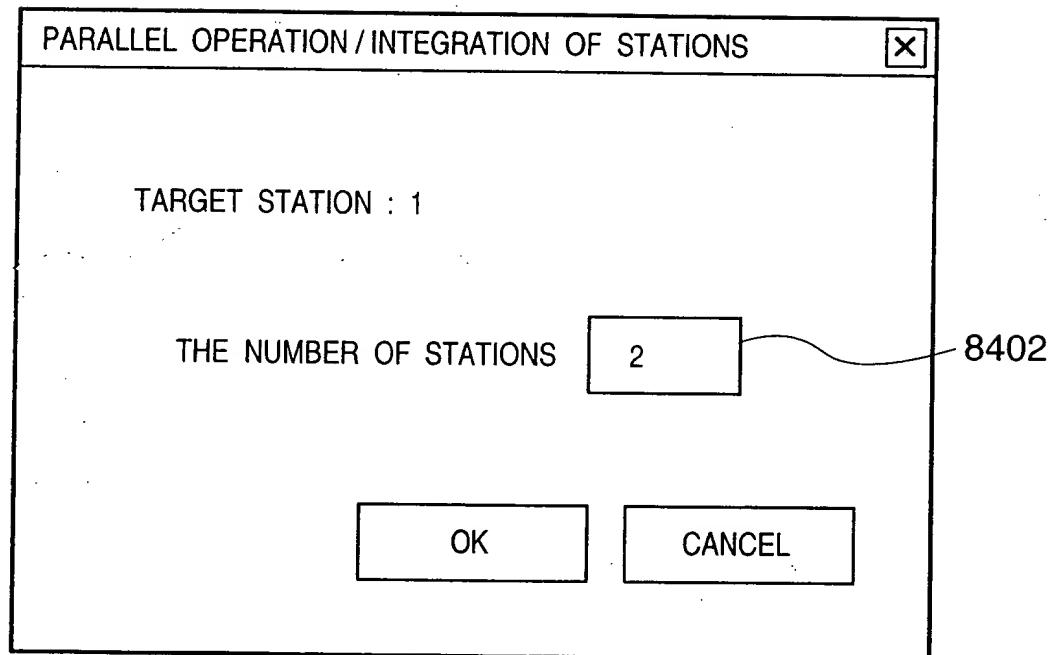
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FIG. 80

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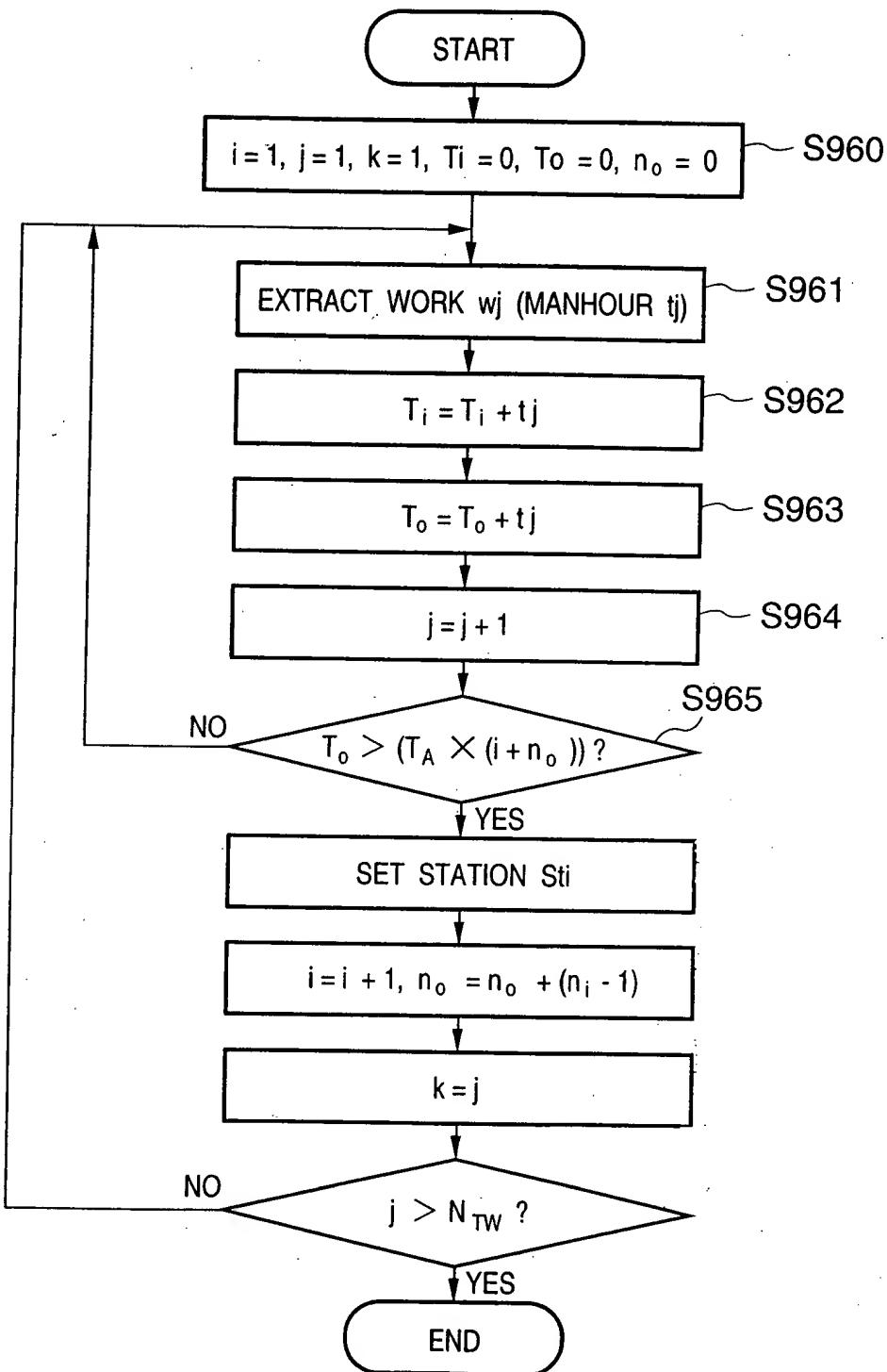
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FIG. 96

 N_{ST} : THE NUMBER OF STATIONS T_i : i STATION MANHOUR

TA : STATION MANHOUR AVERAGE VALUE

$$T_A = WF / N_{ST}$$

To : TOTAL ACCUMULATED MANHOUR

 n_i : i STATION PARALLEL NUMBER n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

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